

Work Order ID 133369

Monday, June 08, 2015 11:10:45 AM

133369

RUSH

Page 1

Item ID: D5208-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blanking Plate
 Start Date: 6/8/2015 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 6/8/2015 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUN 08 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5208	A								

100 FLOW WATER JET 0.00
100
 Waterjet **(24)** DC 15/06/09
 FLOW CNC Waterjet
 304 24 GA.
 Memo
 1-Cut as per Dwg
 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC **(24)** DC 15/06/09
 Quality Control
 Memo

120 QC8- Inspect parts - second check 0.00
120
 QC **(24)** DC 15/06/09
 Quality Control
 Memo
 DAS
 38
 9-89
 JUN 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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Picklist Print

Monday, June 08, 2015 11:10:48 AM

Page 1

Work Order ID: 133369

133369

Parent Item: D5208-1

D5208-1

Parent Item Name: Blanking Plate

Start Date: 6/8/2015

Required Date: 6/8/2015

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A 15.01.29 NEW ISSUE DD VERF:JLM IPP
REV:B 15.05.28 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S24GA		Purchased	No				sf	36.6000		3			

M304S24GA

304/316 .025 Sheet

06/15/09

Location

Loc Qty

Loc Code

MAT020

36.6

m131723

36.6

2.1

DQA: _____ Date: _____



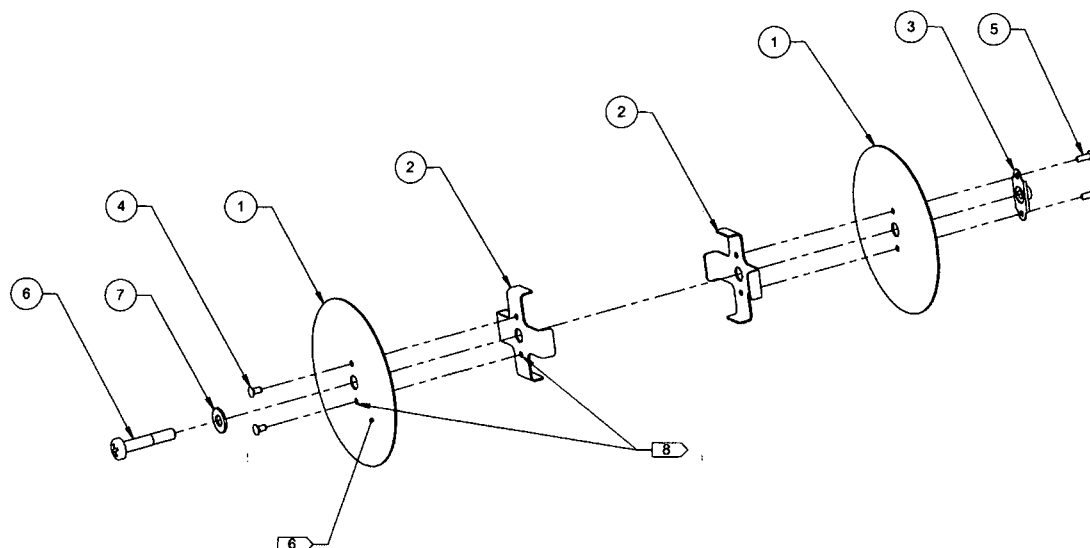
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OTHER : _____																					

ITEM	QTY	P/N	DESCRIPTION
	X	D5208-041	BLANKING PLATE ASSY
1	2	D5208-1	BLANKING PLATE
2	2	D5208-3	GUIDE
3	1	FM5001-050	ANCHOR NUT, FLOATING
4	2	MS20427M3-3	RIVET, SOLID, CSK
5	2	MS20615-3M3	RIVET, SOLID, PAN-HEAD
6	1	LN9038-05-26	SCREW, PAN-HEAD
7	1	BS4320-A5	WASHER



D5208-041 BLANKING PLATE ASSY

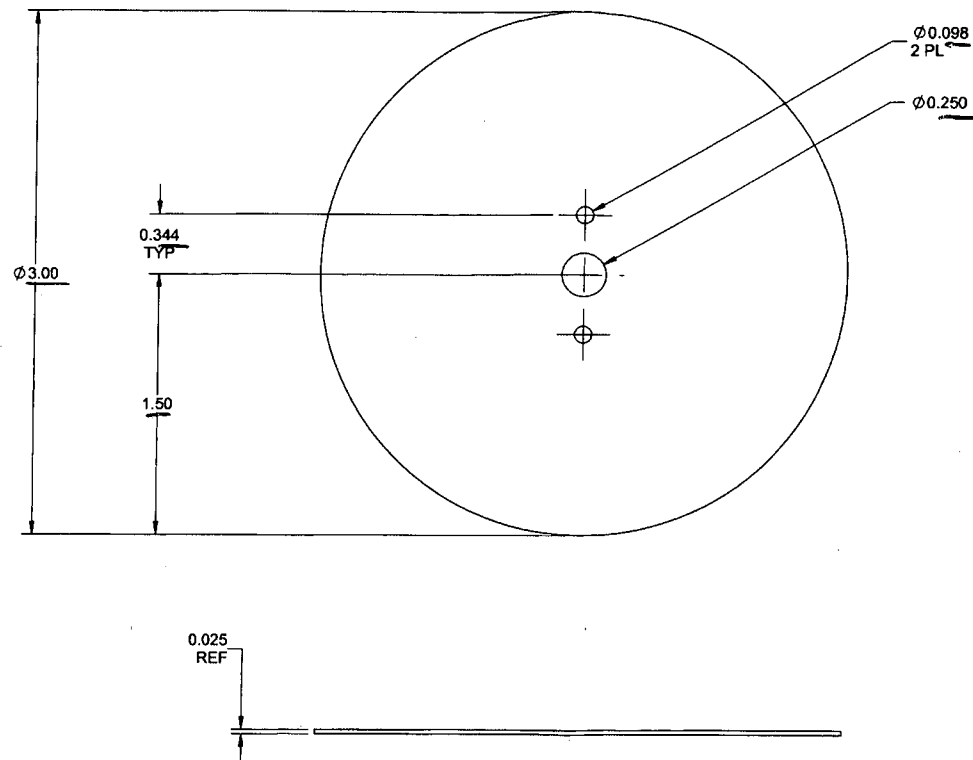
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
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WORK ORDER
NO. 133369 MCT
15-06-08

RELEASED
2015 MAY 28 OM
ECN 15-527

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) DIMPLE THIS FACE OF D5208-1/3 PRIOR TO INSTALLING RIVETS

A		NEW ISSUE		AK	15.01.13
REV.	DESCRIPTION			BY	DATE
DESIGN	AK	DART AEROSPACE LTD		REV. A	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 4	
CHECKED	VS	DRAWING NO.		REV. A	
MFG. APPR.	JLM	D5208		SCALE	
APPROVED	HS	TITLE		NTS	
DE APPR.	DS	BLANKING PLATE			
DATE	15.01.13			COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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D5208-1 BLANKING PLATE

NOTES:

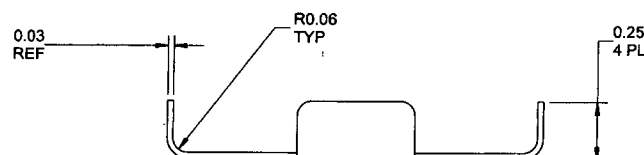
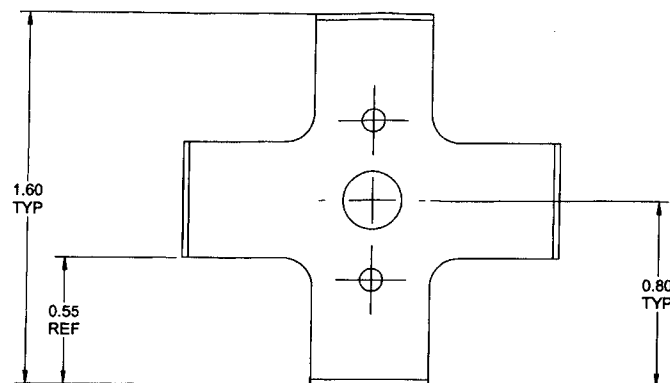
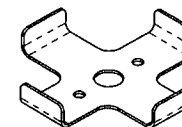
- 1) MATERIAL: AISI 304/316 SS SHEET, 24 GAUGE
ANNEALED
PER MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

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2015 MAY 28

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DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO. D5208	REV. A
MFG. APPR.	JLM	TITLE BLANKING PLATE	SHEET 2 OF 4
APPROVED	HS		SCALE
DE APPR.	DS		NTS
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D5208-3 GUIDE

RELEASED

2015 MAY 28 *AK*

NOTES:

- 1) MATERIAL: MAKE FROM D5208-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

APPROVED

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO. D5208	REV. A
MFG. APPR.	JLM	TITLE BLANKING PLATE	
APPROVED	HS		
DE APPR.	DS	SCALE NTS	
DATE	15.01.13		

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2015 MAY 28 *ph*

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5208	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BLANKING PLATE	NTS
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